



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-751-011
Job Sheet 179637



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skirt tube with Standard Wearplates Fits LH or RH



Part Weight: 1 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 8/2/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev: A 44353 New Issue JLM IPP Rev: B 06-12-18 As per Rev B JLM IPP Rev: C 07-12-11 ECN 1036 as per rev B DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev: F 10.06.09 remove seq110 DD verf: EC IPP Rev G 10.09.17 added D3507-1-bent EC verified: DD IPP Rev: H 13.12.11 ECN13-619/ CHG002 DD VERF: JLM

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
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Container No: S091307



Part: D135-751-011

Job No: 179637

Serial No/Batch: S091307

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/12/18

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/2/18	0.00	0.00	Start Up Skidtubes-1		<i>DD</i>
120	Skidtubes	1 pcs		8/2/18	0.00	0.80	Skidtubes-1		<i>DAS 38</i>
140	QC	1 pcs		8/2/18	0.00	0.00	QC5		<i>38</i>
150	HandFinish	1 pcs		8/2/18	0.00	0.33	HandFinish1		<i>SA 18-07-18</i>
160	QC	1 pcs		8/2/18	0.00	0.00	QC7-1		<i>BE</i>
170	Skidtubes	1 pcs		8/2/18	0.00	1.00	Skidtubes-1		<i>BE DAS 38</i>
180	QC	1 pcs		8/2/18	0.00	0.00	QC10		<i>38</i>
185	HandFinish	1 pcs		8/2/18	0.00	0.10	HandFinish6		<i>SA 18-09-20</i>
187	QC	1 pcs		8/2/18	0.00	0.00	QC7-1		<i>BE</i>
190	Skidtubes	1 pcs		8/2/18	0.00	0.77	Skidtubes-1		<i>BE DAS 38</i>
200	QC	1 pcs		8/2/18	0.00	0.00	QC5		<i>38</i>
210	HandFinish	1 pcs		8/2/18	0.00	0.08	HandFinish2		<i>J.Y. 38</i>
215	Outsource	1 pcs		8/2/18			ATE003-VC	5	
220	SprayPaint	1 pcs		8/2/18	0.00	0.25	Spray Paint		<i>AL JUL 20 2018</i>
230	QC	1 pcs		8/2/18	0.00	0.00	QC14		<i>BE 18-7-27</i>
260	HandFinish	1 pcs		8/2/18	0.00	0.74	HandFinish4		<i>BE DAS 38</i>
270	QC	1 pcs		8/2/18	0.00	0.00	QC5		<i>38</i>
280	Packaging	1 pcs		8/2/18	0.00	0.00	Packaging1-1		<i>JUL 26 2018</i>
290	QC	1 pcs		8/2/18	0.00	0.00	QC4		<i>DAS DAS DAS 6 6 27 JUL 27 2018</i>
300	Packaging	1 pcs		8/2/18	0.00	0.00	Packaging3-1		<i>9-89 9-89 9-89 JUL 27 2018</i>
305	DC	1 pcs		8/2/18	0.00	0.00	DC		<i>JUL 27 2018</i>
310	QC21-FG	1 Ea		8/2/18	0.00	0.00	QC21		<i>DAS JUL 27 2018</i>

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Plot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

*S. KAFLEY
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170 - 1-Open X-Bolt holes to .375" (1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : JULY 18 end time: JULY 19 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: 5084461 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: 138886

260 - 1- Install Wearplate &Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 5080995

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	004616
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5089120
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	5077472
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	8105604
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5071543
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	5076673
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	5070880
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	8131267
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5092687
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5058138
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5045662
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5068642
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5057153
D2965	Cap	1 Ea (1 ea)	260-HandFinish	50716642
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	5045482
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	F126369
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5077522
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	5091848
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	F10611C
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5081680
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5082202
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	x 5089864
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5036799
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	5056493
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	F103697
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5049970
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5077839
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5090630
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5094407
				5049827

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	0	0
170-Skidtubes	D3504-1	2	28	0
	D3504-3	1	26	0
	D3504-5	2	14	0
	D3505-1	1	4	0
190-Skidtubes	D3506-1	4	17	0
	D3506-3	2	8	0
	MS20601-AD4W3	12	1,163	0
260-HandFinish	ALS4-1032-225	1	4,460	0
	ALS7-1032-130	38	1,389	0
	AN3C4A	31	1,807	0
	AN3C5A	2	1,655	0
	AN526C1032R10	2	178	0
	D2965	1	80	0
	D2965-3	1	30	0
	D3492-1	4	272	0
	D3492-3	4	103	0
	D3492-7	2	35	0
	D4918-047	1	8	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	9	0
	NAS1149C0332R	33	5,349	0
	NAS1611-007	2	286	0
	NAS1611-010	4	453	0
	NAS1611-013	4	349	0
280-Packaging	AN3C4A	8	1,807	0
	D3512-041	2	15	0
	NAS1149C0332R	8	5,349	0

Part Specifications

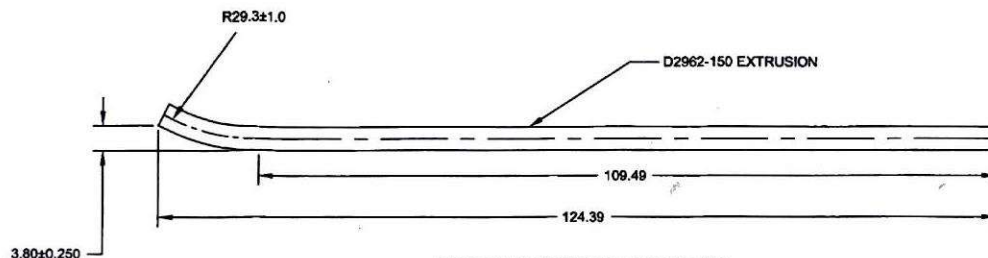
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Plex 6/20/18 1:08 PM dart.white.jesse

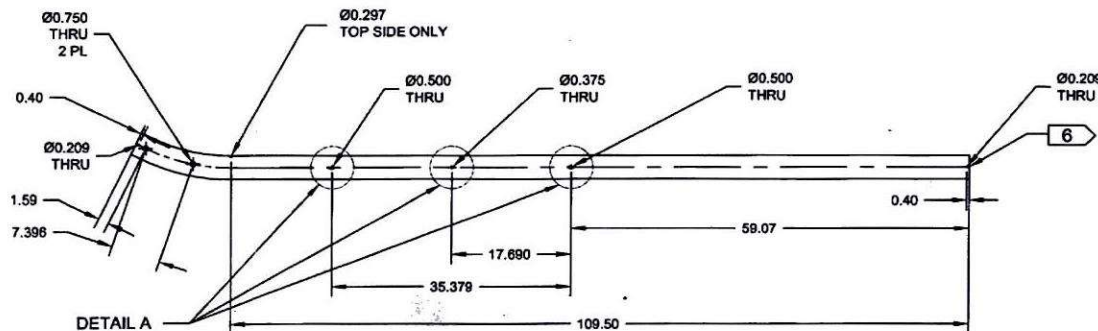
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3482-041	PLUG ASSEMBLY
4	D3482-043	PLUG ASSEMBLY
2	D3482-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AEIS-1032-130	INSERT
1	AEIS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

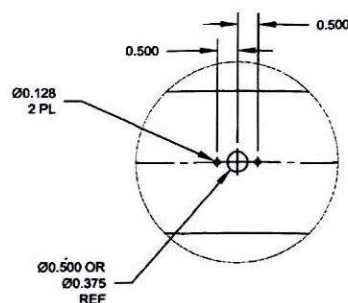
- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
 OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART BN PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- WEIGHT: 24.1 LB (FROM IIN-D135-751)
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AEIS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



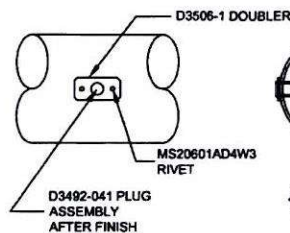
D3507-1 DRILLING DETAIL



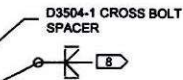
DETAIL A
TYP. 6 PL
SCALE 3:10

D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA DRAWING NO. D3507 TITLE EC 135 SKIDTUBE SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	
DRAWN	DW		
CHECKED	UP		
MFG. APPR.	AA		
APPROVED	MP		
DE APPR.	CH		
DATE	13.08.30		

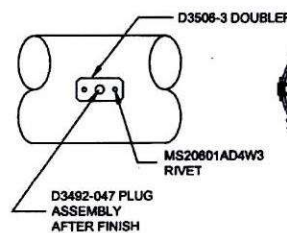
RELEASE
2013-12-10



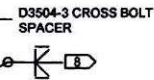
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(SCALE 3:10)



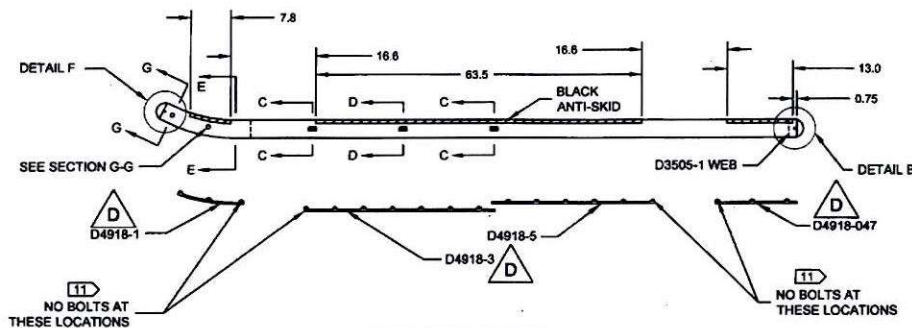
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (7" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL



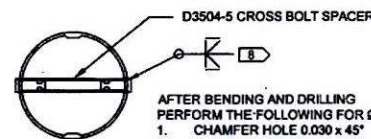
SECTION D-D
(SCALE 3:10)



- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (7" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL

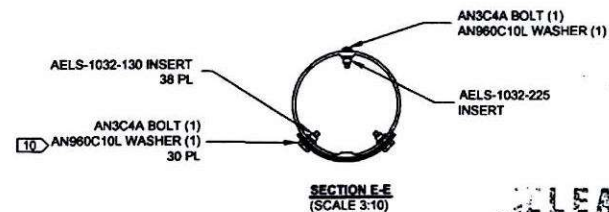
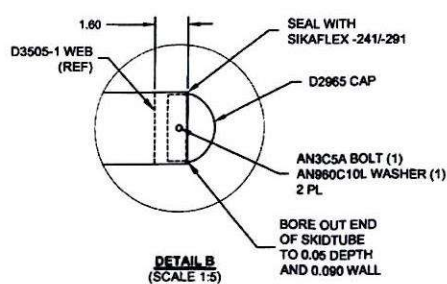
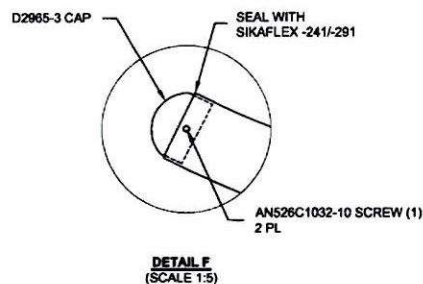


D3507-041 ASSEMBLY DETAIL



SECTION G-G
(SCALE 3:10)

- AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



RELEASED
2013-12-13

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	SW	DRAWING NO.	REV. D
MFG. APPR.		D3507	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Kim Johnston

From: Sonia Quirion
Sent: Thursday, July 26, 2018 9:41 AM
To: Michelle GagnonDonovan
Cc: Kim Johnston
Subject: L/B

d135-751-011 s091307 s091301 RED AND WHITE

3 0 7

Part Number: D135-751-011[illegible]